



# Inspection certificate EN 10204 Type 3.1

Doc-no. MF 713R / 3.1 / C / Rev.B



Delivery note no.: 80110885

Customer: Mellolit AB  
JA Gahms Gata 4  
SE-421 32 Västra Frölunda

Customer order no.: 27881

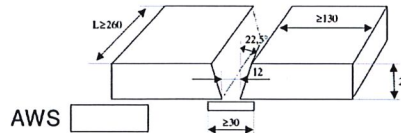
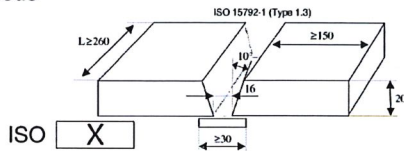
Quantity delivered: 3 072,00 KG  
Customer: (to be filled in by customer)

Quantity delivered: (to be filled in by customer)

Type: **MEGAFIL 713 R**  
Diameter Ø: **1.2 mm | 0.045"**  
Batch: **041659**  
Specification: **T 46 2 P C1 1 H5**  
ISO 17632 A: **E71T-1C-J H4**  
AWS ASME 5.20: **E71T1-C1A0-CS1-H4**  
AWS ASME 5.36: **42.027.03**  
DB-type certificate: **07602**  
TÜV-type certificate: **T4**  
Lot classification: **1**  
Testing schedule: **1**

Current: **±/DCEP** 240 A  
Voltage: **26,5** V  
Welding speed: **20-25** cm/min  
Shielding gas / Flux: **CO2**  
Flow rate: **15** l/min  
Stick out: **20-15** mm  
Position: **PA (1G)**  
Interpass temp.: **150** °C 302 °F

## Test methods



## ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,03	0,37	1,08	0,012	0,007	0,017	0,019	0,005	0,138	0,005	0,016	0,032	0,015	0,010
ISO													
		max.			max.	max.	max.	max.		max.		max.	
		2,00			0,20	0,50	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.									
0,12	0,90	1,75	0,03	0,03									

## Mechanical properties of the pure weld metal

Heat-treatment	Tensile test ISO 5178			Impact test ISO 9016 VWT 0/b									
	Rm [MPa]	Rp0,2 [MPa]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	531	483	30			139					102		
	min. 530	min. 460	min. 20			88					65		
	[ksi]		[%]			134					99		
	77	70	30			120					89		
	min. 77	min. 67	min. 20										

Name: Jutzi  
Date: 17.05.2021

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